

Work Order ID 64080

Wednesday, November 24, 2010 8:38:05 AM

Page 1

Item ID: D2583

Accept

Setup Start

Revision ID:

Stop

Item Name: Latch Bracket

Start Date: 11/24/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

10-11-30

32

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-11-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10/11/30

count
32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item ID:	D2583	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Latch Bracket					
Start Date:	11/24/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	11/30/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951.</i> Memo START TIME: <i>12:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:30.</i>	0.00 0.00				<i>32</i>		<i>10-12-2.</i>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>=) M</i>	<i>10/12/02</i>		<i>32</i>	<i>d</i>		
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>A</i> Memo	0.00 0.00				<i>10/12/12</i>		<i>Sf B2V</i>	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 64080

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Wednesday, November 24, 2010 8:38:05 AM

Item ID: D2583

Accept



Setup Start



Revisor ID:

Stop



Item Name: Latch Bracket

Start Date: 11/24/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/03

PS-10-12-2

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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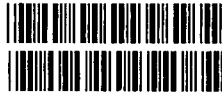
NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:38:10 AM

Page 1

Work Order ID: 64080



Parent Item: D2583

Parent Item Name: Latch Bracket

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat- in house process DM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

24.8234

0.1169

2.461053

4.



1810-11-30

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT

16.3

114488

16.3

MAT23

8.5234

101875

1.5

109058

5.6234

113123

1.4

109058

30

W/O:		WORK ORDER CHANGES					
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QA COPY ISSUED

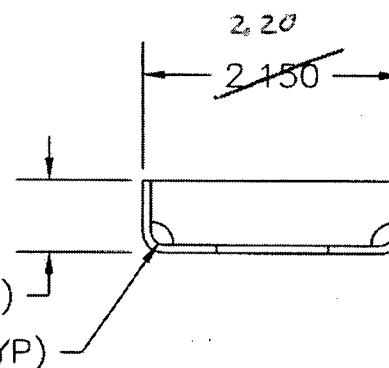
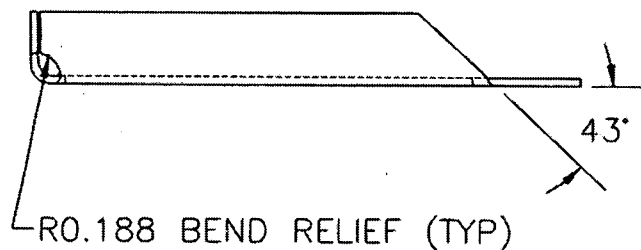
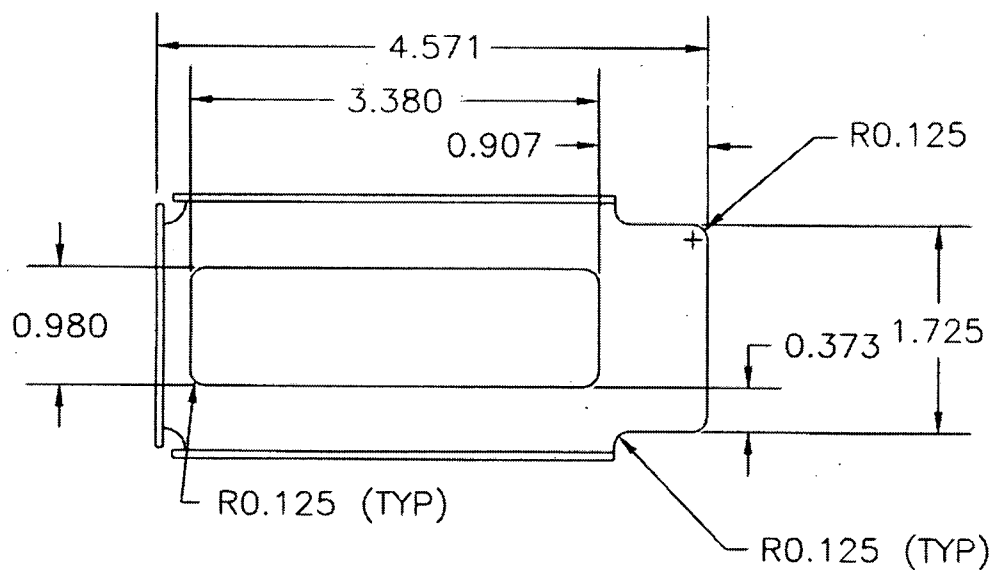
RECEIVED
JUN 20 1962

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44480



NO. 44080

BP10-11-24

KE
940220



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHECKED 		APPROVED 		DRAWING NO. D2583		REV. B SHEET 1 OF 1	
DATE 99.02.22		TITLE LATCH BRACKET		SCALE 2:3			
A 96.07.10		NEW ISSUE					
B 99.02.22		CHANGE OF FINISH (PER TSR A887)					